

Work Order ID 65297

January 11, 2011 9:18:15 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 1/21/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MP*

Date: 11-01-11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

8/10/24

Handwritten signature BG 11-02-23

(10)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R: Aluminum Rod

3-Grind End Plate flush

1108436
1115923

Handwritten signature 11-02-12 10

Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65297

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>10</u>	<u>0</u>	<u>3E 11/02/14</u>	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u> <u>24</u>			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>10</u>	<u>0</u>		

5.11.02.14

11.02.15

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10	4	110215	
180 	Large Fab	0.00							
Large Fab	Memo	0.00				10	4		
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R <input type="checkbox"/> Aluminum Rod <u>M108436</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

11.02.16

W/O:		WORK ORDER CHANGES					
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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE11/02/11	
200  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10	0		
210  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10 LH	0	11/02/22	

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>M115951</i>					<i>10</i>	<i>11-2-22</i>		
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:10</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>4:10</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch								
	<i>M116467</i>								
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

106H 6 M1106/23

11/24 102

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/2/23

1028

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

ml

11

02

24

102

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: 11/2/24

REV B

11/2/24

102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 JG

MF
11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-591-311




Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/21/11**Required Date:** 2/18/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1  Step		Manufactured	No			110	Each	20.0000	1	10		11.02.09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA <u>365300</u>				20		<u>10</u>			
				64910				10					
				64911				10					
D3067-1  End Plate		Manufactured	No			110	Each	116.0000	1	10		11.02.12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA <u>365969</u>				116		<u>1</u>			
				60141				2					
				62664				6					
				<u>63550</u>				108		<u>98</u>			
D3219-1  Plate		Manufactured	No			110	Each	113.0000	2	20		11.02.12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				113					
				63551				113		<u>20</u>			

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 65297

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

D3066-1

Manufactured No

180

Each

86.0000

2

20



Spacer



11.02.16

Location

Loc Qty

Loc Code

WA

365072

86

20

63549

86

MS20600-AD4W4

Purchased

No

180

Each

2,351.000

16

160



Rivets



11.02.16

Location

Loc Qty

Loc Code

ST321

116712

2351

160

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

D3065-041

Manufactured

No

180

Each

42.0000

1

10



Step Leg Assembly Hi



11.02.16

Location

Loc Qty

Loc Code

WA

363554

42

10

63324

2

63555

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180 Each

116.0000

1

10



End Plate

Location

Loc Qty

Loc Code

WA

B65969

116

60141

2

62664

6

63550

108

10

AN3-35A

Purchased No

250 Each

168.0000

2

20



Bolt

Location

Loc Qty

Loc Code

ST353

168

116191

100

116419

18

116549

50

D3235-1

Manufactured No

250 Each

61.0000

2

20



Mounting Lug

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041

Manufactured No

250 Each

8.0000

1

10



Support Assembly

Location

Loc Qty

Loc Code

ST460

8

64731

8

B63553

B66155

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Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

30.0000

16

1600x

149x



M116304

M116305 11/2/23

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

40



M116540

11/2/23

Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A Purchased

No

250

Each

151.0000

2

20



11/2/23

Bolt

Location

Loc Qty

Loc Code

ST341

151

114292

1

116191

100

116549

50

D2618 Manufactured

No

250

Each

36.0000

2

20



B6504

B66130

10x

Bushing

Location

Loc Qty

Loc Code

ST019

36

63548

36

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Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

94.0000

4

40



Lug



B66126 10/2/24sf

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80

D2856-400

Manufactured No

250

f

272.5810

1.2

12



Abraison Strip



11/2/24sf

Location

Loc Qty

Loc Code

ST403

272.5810421

56626

0.00004211

59920

56.581

63735

216

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3 ?

Purchased No

250

Each

3,274.000

2

20



Nut



11/2/23sf 102

Location

Loc Qty

Loc Code

ST300

3274

114784

9

115835

765

116391

900

116540

800

116549

800

20

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Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

185.0000

8

80



Bolt



11/16/69

11/2/238

Location

Loc Qty

Loc Code

ST357

185

116191

185

MS2T042L5

Purchased

No

250

Each

1,357.000

2

20



Nut



11/2/238

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1331

115156

5

115594

500

116104

130

116105

496

116548

200

MS2T042L4

Purchased

No

250

Each

4,846.000

8

80



Nut



11/2/238 100

Location

Loc Qty

Loc Code

ST300

4846

1123143

2

115589

10

115621

334

116188

3500

116548

1000

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Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

AN960JD10

NAS1149D0363J Purchased

No

250

Each

8.0000

4

40 32x



Washer



MIL6007

MIL6583

11/2/03

5/

102

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

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DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *[Signature]*

#65297

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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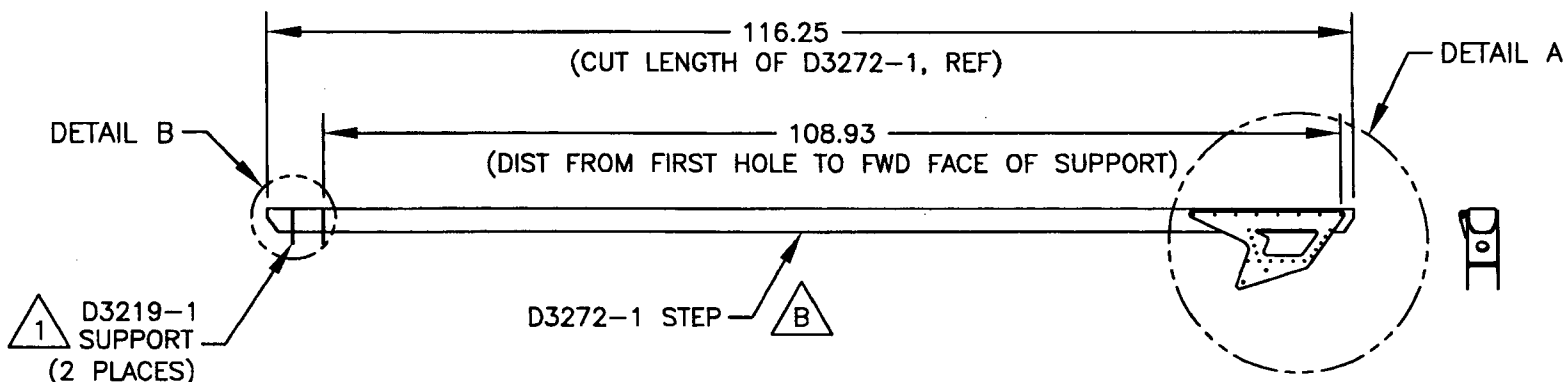
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

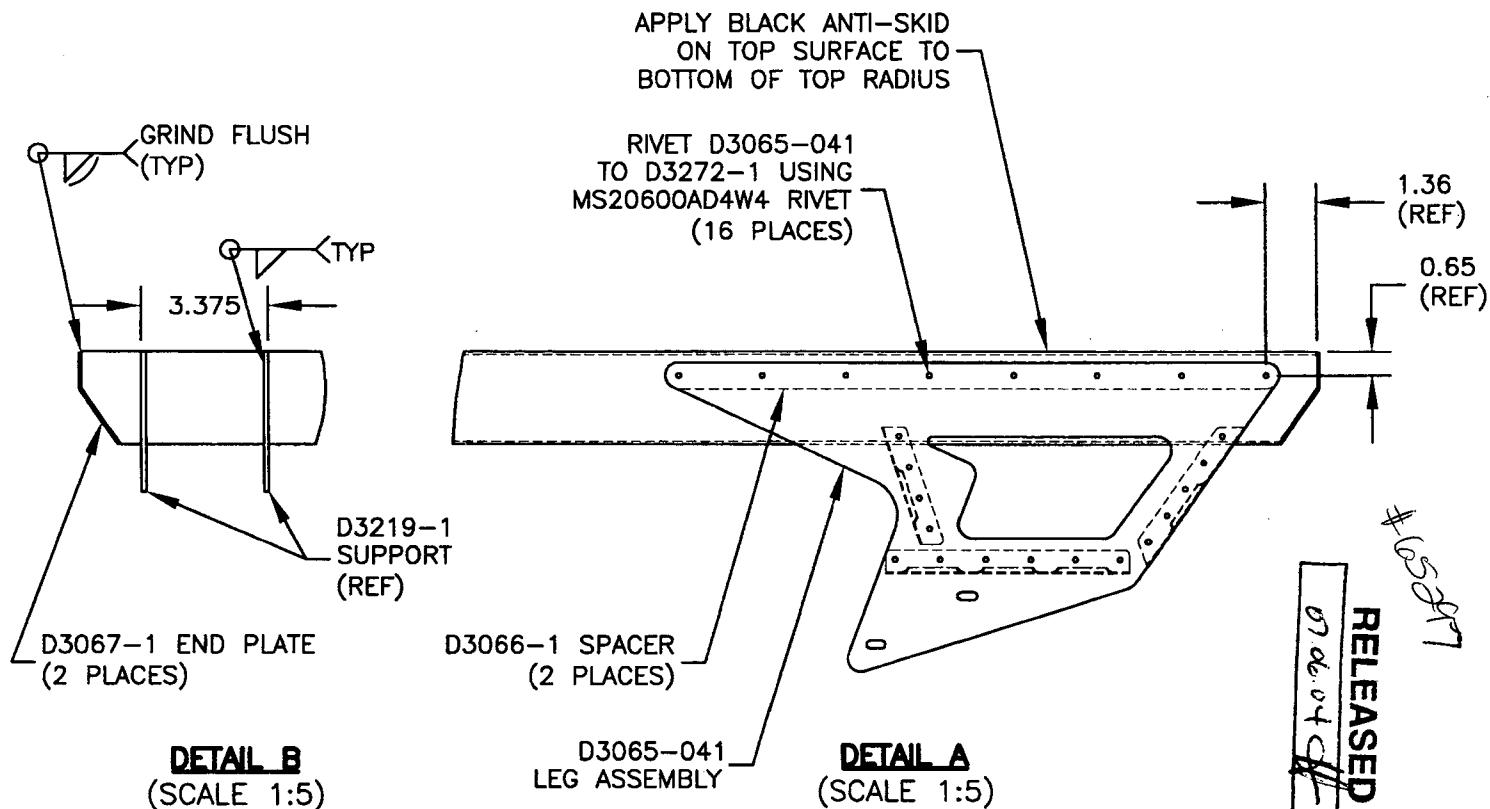
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

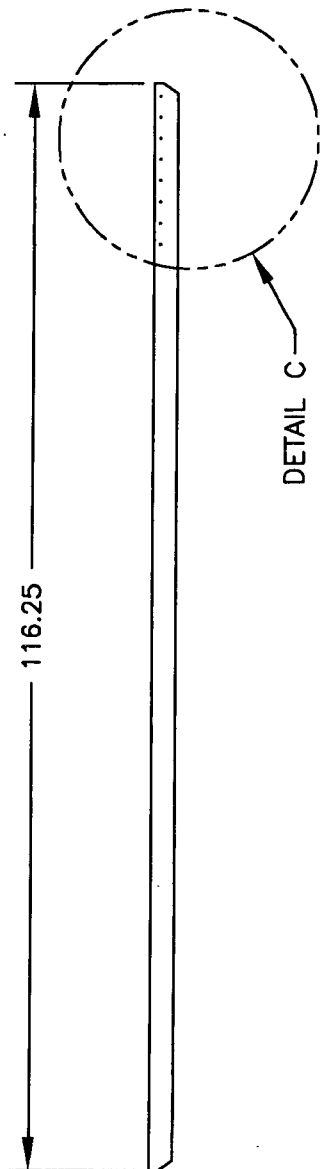


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

#65297

RELEASED

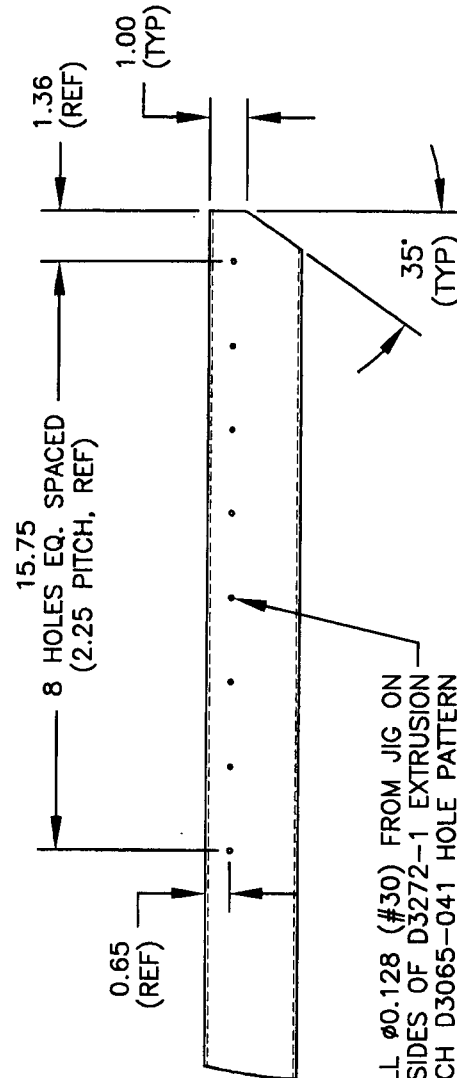
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C

(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**

Date: 08.10.06